

Work Order ID 59084

Monday, May 31, 2010 8:54:44 AM

**DUPPLICATE**

Page 1

Item ID: D3914-041

Accept



Setup Start



Revision ID:

Item Name: Long Basket Lid Assembly (350)

Stop



Start Date: 5/26/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 6/3/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *MJF*Date: *10-5-21* Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3914	A

100 Weld per dwg A/R S.S. rod Batch: *1113328* 0.00

Large Fab

Memo 0.00

1- assemble ribs , weld as per dwg D3914 using DT9607A
 2- weld hinge (3) and Mounting brackets as per dwg D3914
 inspect before welding mesh
 3- tack weld mesh on basket as per dwg D3914 *AS*
 ***make sure to place mesh correctly on lid, check with label plate before
 tacking mesh*** *AS*

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

QC

Memo 0.00

Quality Control

*May 31/06/03**GPC 10-06-03*

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

120



QC

Quality Control

Operation
Description

QC5- Inspect part completeness to step on W/O

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

S 10/06/03

@

130



Powdercoat

Powder Coating

Black Sandtex(Ref:4.3,5.7) per QSI005 4.3

M112588

0.00

=> M 10/06/04

0.00

1

8

140



HandFinish

Hand Finishing

Wing Walk as per dwg QSI005 4.4 Batch

M114432

0.00

1- Mask data plate and apply wing walk on outside surface of mesh as per dwg

2- Install placard and label as per dwg

D

BK 10-6-04.

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Picklist Print

Monday, May 31, 2010 8:54:43 AM

Page 1

Work Order ID: 59084



3

Parent Item: D3914-041



Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 5/26/2010

Required Date: 6/3/2010

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2581 		Manufactured	No			100	Each	30.0000	2	2		<i>PD 10.05.31</i>	

Mounting Bracket

Location	Loc Qty	Loc Code
WA	30	
46086	2	
51745	2	
57185	1	
58301	5	
58687	20	

D3914-1



Manufactured

No

100

Each

0.0000

2

(2)

*PD 10.05.31
B39023 (2)*

Rib

D3914-7



Manufactured

No

100

Each

4.0000

2

(2)

PD 10.05.31

Rib

D4016-3



Hinge Half, Lid

Manufactured

No

100

Each

10.0000

3

(2)

PD 10.05.31

Location	Loc Qty	Loc Code
ST116	10	
58243	10	

(3)

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Required Qty: 1.00

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D4018-5 		Manufactured	No			100	Each	45.0000	9	9		10.05.31	
Rib							<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
				WA			45						
				58594			9						
				58669			18						
				59097			18						
D4020-5 		Manufactured	No			100	Each	1.0000	1	1		10/06/03	
Mesh (350 Basket Long, Lid)							<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
				WA			1						
				58691			1						
D4021-3 		Manufactured	No			100	Each	2.0000	1	1		10.05.31	
Data Plate							<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
				WA			2						
				56050			1						
				58875			1						
D4035-041 		Manufactured	No			100	Each	1.0000	1	1		10.05.31	
Lid Rib Assembly, Fwd (350 Basket)							<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
				WA			1						
				58743			1						

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Page 3

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Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 5/26/2010

Required Date: 6/3/2010

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4035-043	Lid Rib Assembly, Aft (350 Basket)	Manufactured	No		100		Each	1.0000	1	1		DD 10.05.31	
-----------	------------------------------------	--------------	----	--	-----	--	------	--------	---	---	--	-------------	--

Location

WA 1

58744 1

140 Each 0.0000 1 1

D2728-3 Dart Logo label

Manufactured No

140 Each 11.0000 1 1

D4086-210 Placard, Max Load

Manufactured No

140 Each 11.0000 1 1

Placard, Max Load

Location

ST117 11

58926 11

1 DS 10/6/04

1 DS 10/6/04

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ITEM	QTY -041	P/N	DESCRIPTION
X	D3914-041	SHORT BASKET LID ASSY (350)	
1	1	D3914-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4016-3	HINGE HALF, LID
6	1	D4020-5	LID MESH, 350 LONG BASKET
7	1	D4021-3	DATA PLATE
8	1	D4086-210	PLACARD, MAX LOAD

D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION		BY DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	K	DRAWING NO.	REV. A
MFG. APPR.	M	D3914	SHEET 1 OF 4
APPROVED	#	TITLE	SCALE
DE APPR.	#	LONG BASKET LID ASSY (350)	NTS
DATE	10.03.16		

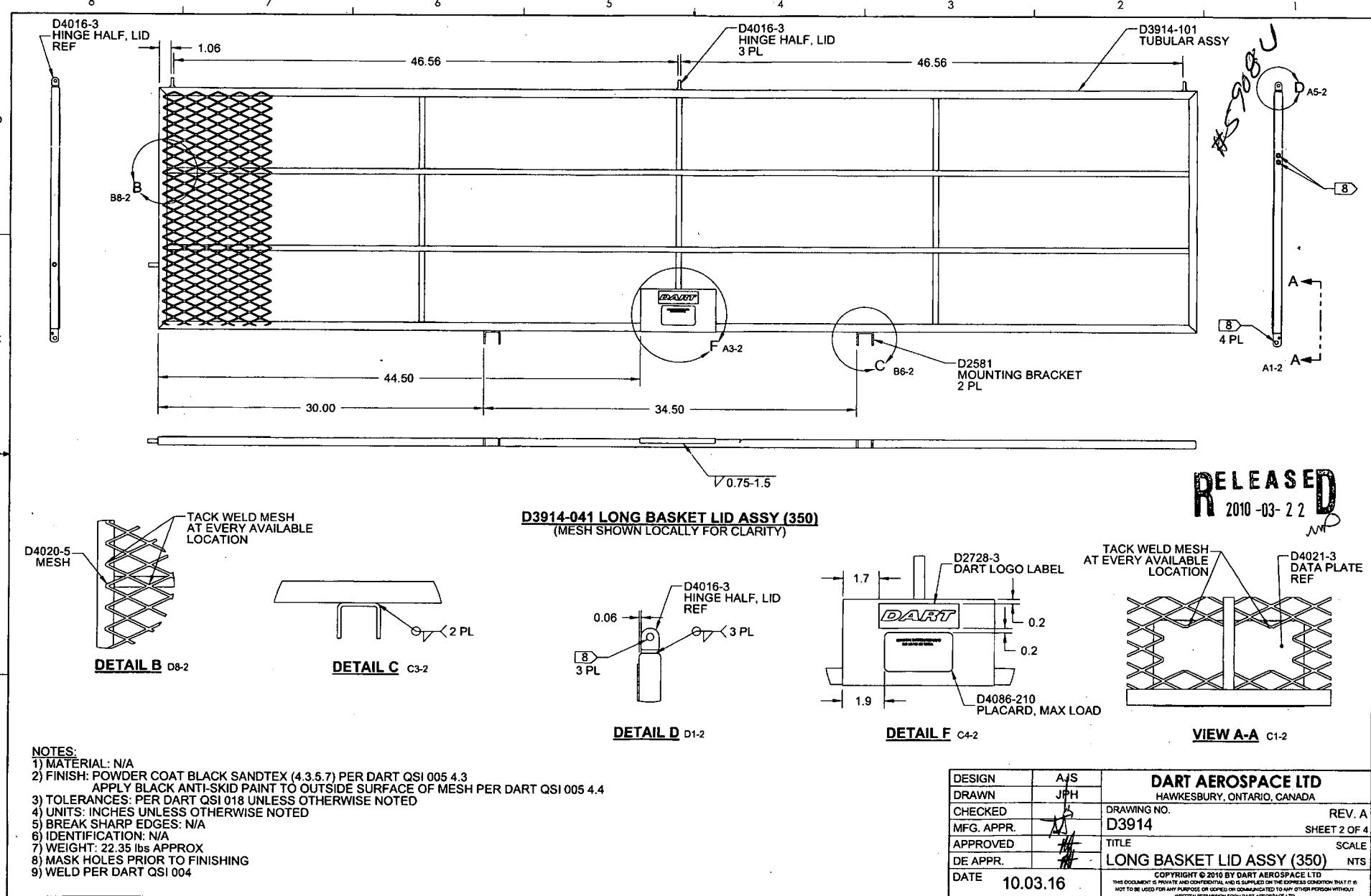
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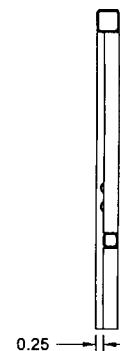
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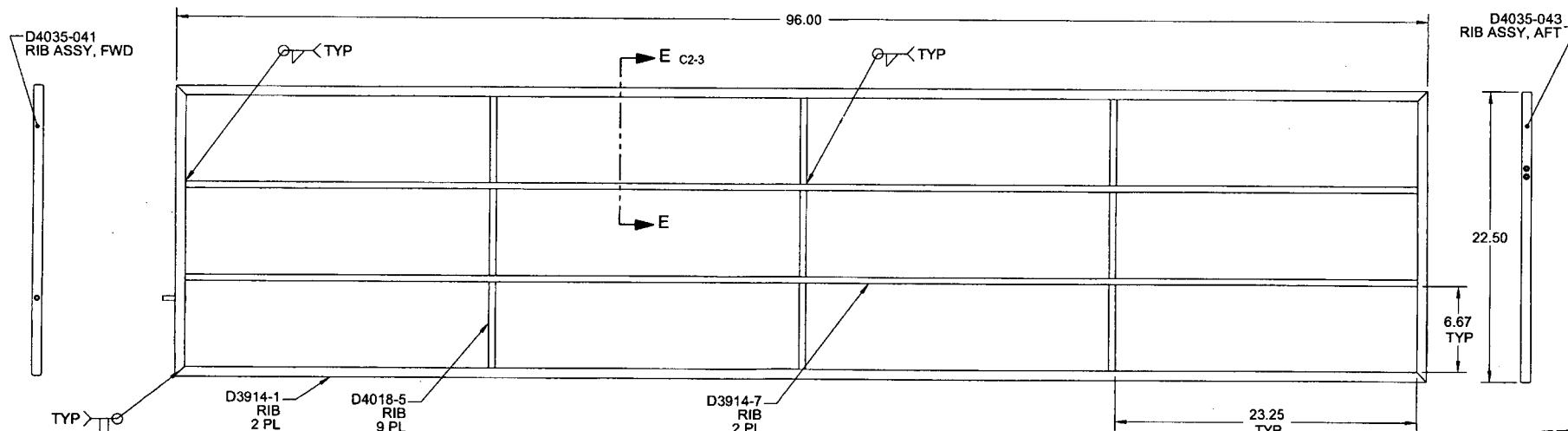
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8 7 6 5 4 3 2 1

ITEM	QTY	P/N	DESCRIPTION
	-101	X D3914-101	TUBULAR ASSY, BASKET LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



SECTION E-E C5-3

RELEASED
2010-03-22
[Signature]

B D3914-101 TUBULAR ASSY, LONG LID

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 14.10 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
- 9) WELD PER DART QSI 004

DESIGN	A/S	DART AEROSPACE LTD			
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA			
CHECKED	<i>[Signature]</i>	DRAWING NO.			
MFG. APPR.	<i>[Signature]</i>	REV. A			
APPROVED	<i>[Signature]</i>	D3914			
DE APPR.	<i>[Signature]</i>	SHEET 3 OF 4			
DATE	10.03.16	TITLE			
		SCALE			
		LONG BASKET LID ASSY (350)			
		NTS			
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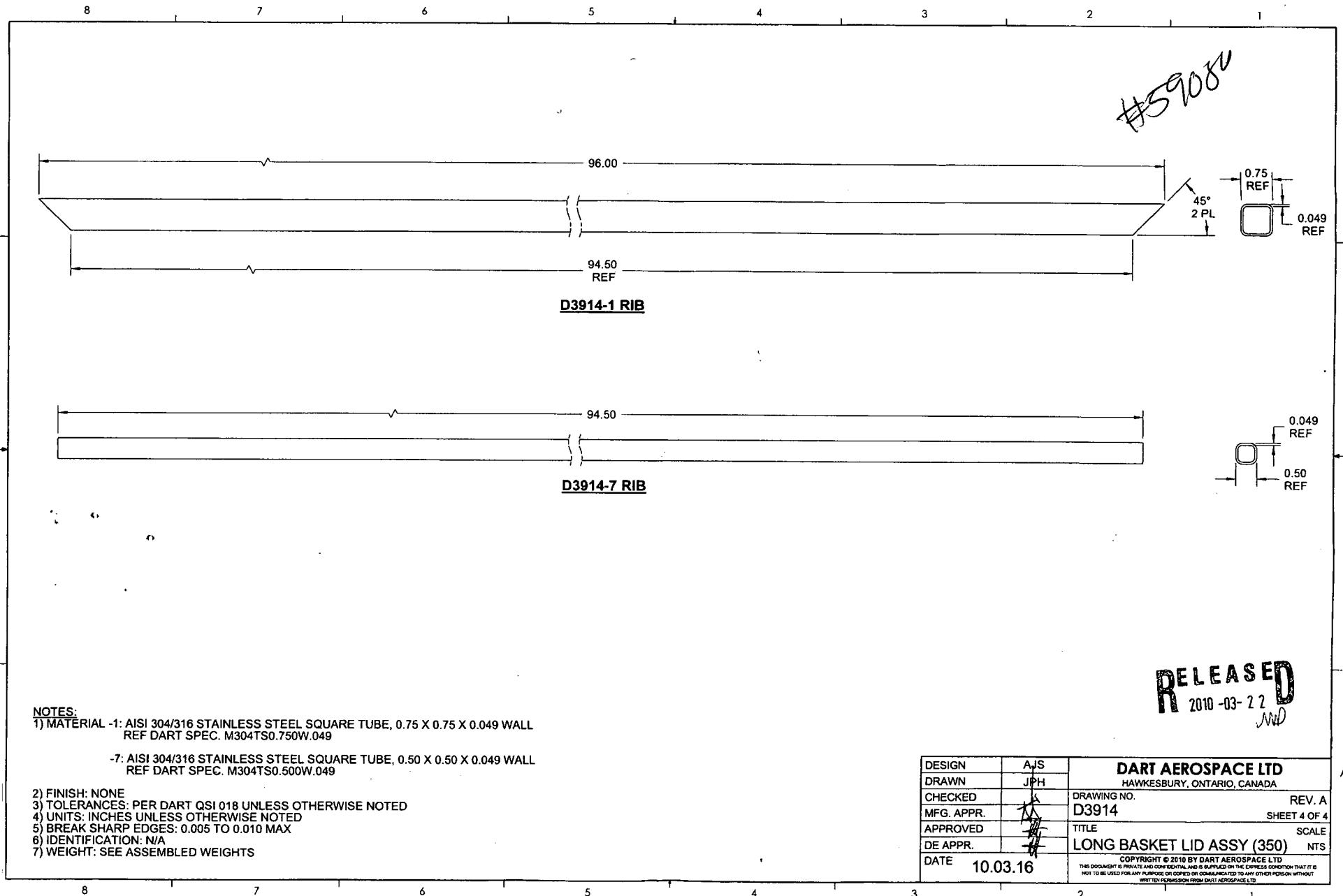
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